

Date: Wednesday, 18/02/2009 7:16:39 AM  
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 45844	
Estimate Number : 10437	
P.O. Number :	Part Number : D33191
This Issue : 18/02/2009 S.O. No. :	Drawing Number : D3319 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 45054	Material :
Written By :	Due Date : 25/02/2009 Qty: 30 Um: Each
Checked & Approved By :	
Comment : Est: B 05.10.14 Added step 9, dwg rev B KJ/EC	
Est Rev:C Now on Waterjet 06-10-26 JLM	

Additional Product

Job Number:



14 sf out of mag

Seq. #: Machine Or Operation: Description :

1.0 M1010S18GA 1010/1025 SHEET .048



10948 x 9 = 6  
100473 x 4 = 2.6  
108184 x 5 = 3.3  
106384 x 2 = 1.3



Comment: Qty.: 0.6594 sf(s)/Unit Total: 7.9128 sf(s)  
1010/1025/A21/6aA SHEET .048  
Batch:

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
1-Cut as per Dwg D3319  
Dwg Rev: B  
Prog Rev: B

AB 9-2-18

2-Deburr if necessary AB 9-2-18

20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

2090.19 20

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr if necessary

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 18/02/2009 7:16:39 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 45844

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

2- Form flat on press using DT8776 block

58 09/02/19 (20)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

209.02.15 (20)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: \_\_\_\_\_

Qty Part Number Description Batch

A/R N/A

7560 Hardcoat Rod

M109560

EL 9-2-20

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 02/02/23 (20)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/02/23 (20) counter

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:15 AM

OVEN TEMPERATURE:

320 C

FINISH TIME:

10:45 AM

21 09-02-23 (20)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 09/02/23 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 18/02/2009 7:16:39 AM  
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Drawing Name: WEARPLATE

Job Number: 45844

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: STU 97

JS 09/02/24 (20)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/24 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



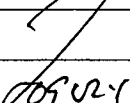
U 09/02/24

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Wearplate		<b>Part Number:</b>	<b>D3319-1</b>
<b>Inspection Dwg:</b> D3319	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

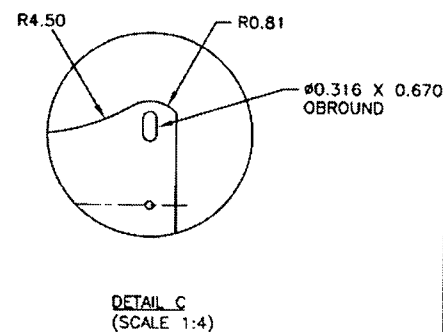
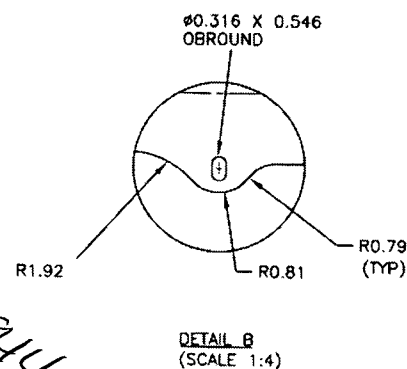
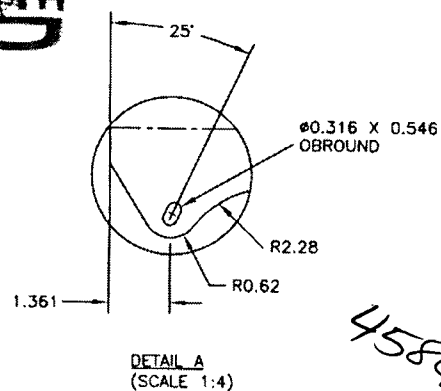
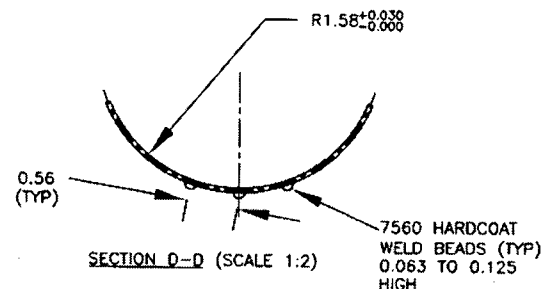
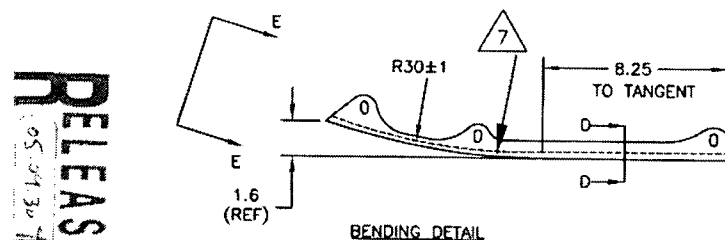
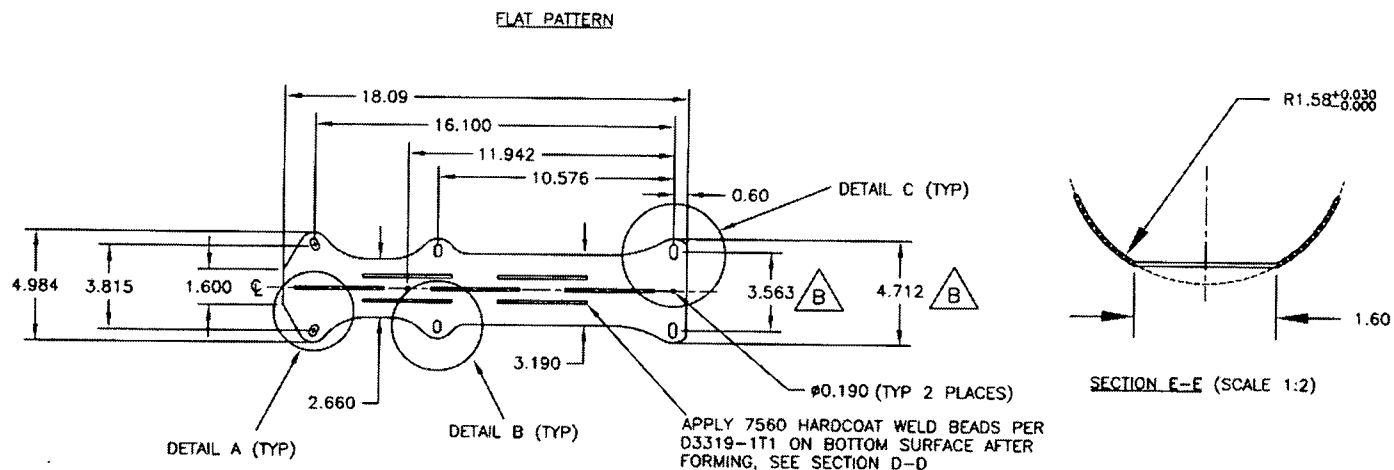
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.984	+/-0.010	4.985	✓			
1.600	+/-0.010	1.607	✓			
2.660	+/-0.010	2.665	✓			
3.190	+/-0.010	3.196	✓			
3.563	+/-0.010	3.563	✓			
4.712	+/-0.010	4.711	✓			
0.60	+/-0.030	.595	✓			
10.576	+/-0.010	10.579	✓			
11.942	+/-0.010	11.947	✓			
18.09	+/-0.030	18.09	✓			
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	316 x .547	✓			
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	316 x .674	✓			
Ø0.190	+0.005/-0.001	.192	✓			

<b>Measured by:</b> MB	<b>Audited by:</b> 	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-2-18	<b>Date:</b> 09/02/19	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	

**DART**



# D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
PH1	844	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	SHEET 1 OF 5
05.06.06	WEARPLATE	SCALE 1:8
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7

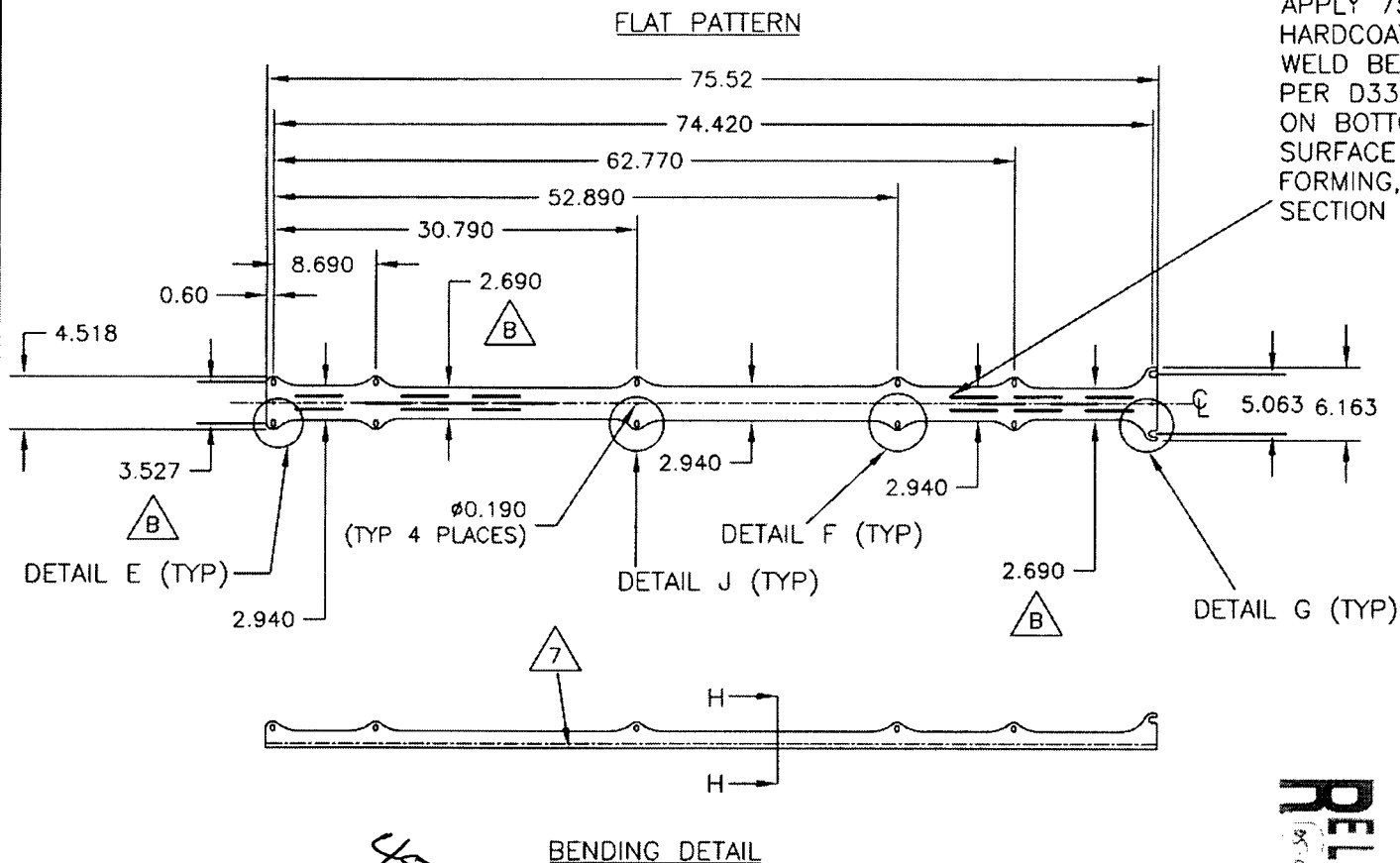
RELEASED  
05-01-30

45844

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED <i>6/7</i>	APPROVED <i>6/7</i>	HAWKESBURY, ONTARIO, CANADA	
DATE	TITLE	DRAWING NO.	REV. B
05.06.06	WEARPLATE	D3319	SHEET 2 OF 5
			SCALE
			1:15

APPLY 7560  
HARDCOAT  
WELD BEADS  
PER D3319-3T1  
ON BOTTOM  
SURFACE AFTER  
FORMING, SEE  
SECTION H-H



#### D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

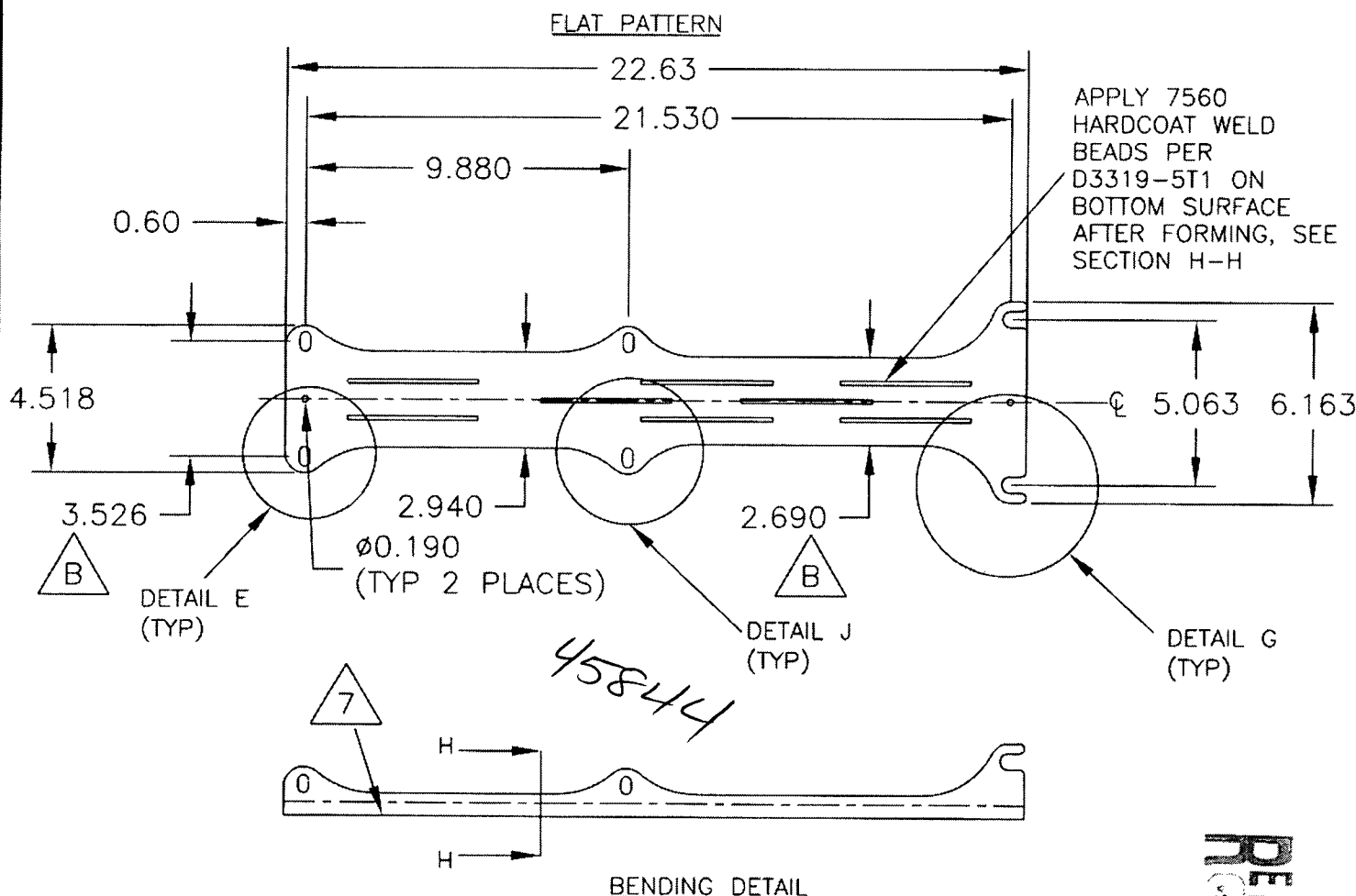
**RELEASED**



**DART**

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CHECKED	GH	APPROVED	GH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 3 OF 5
		SCALE	1:5	

RELEASED

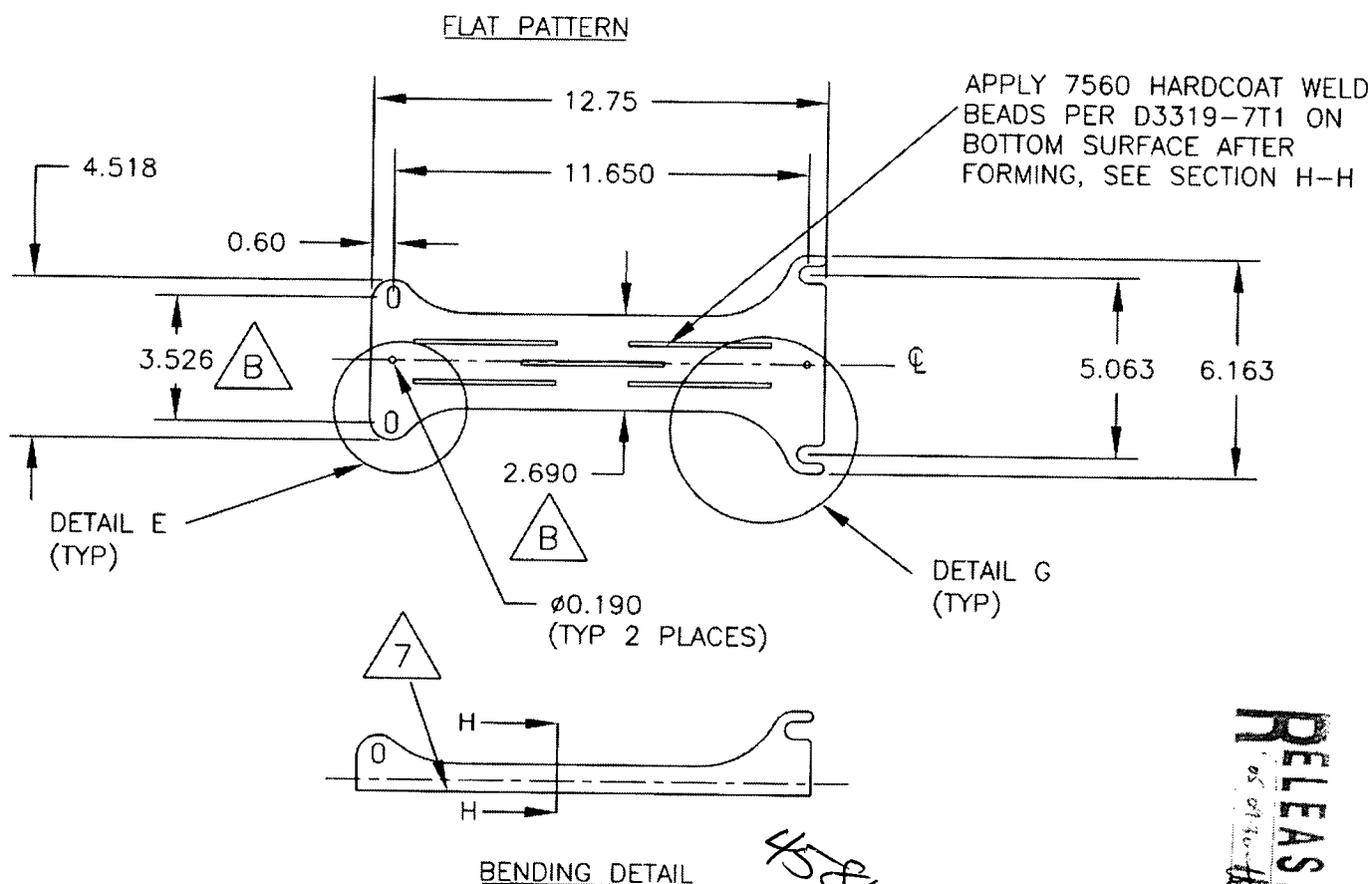


# D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**DART**

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAMKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 4 OF 5
		SCALE	1:5	



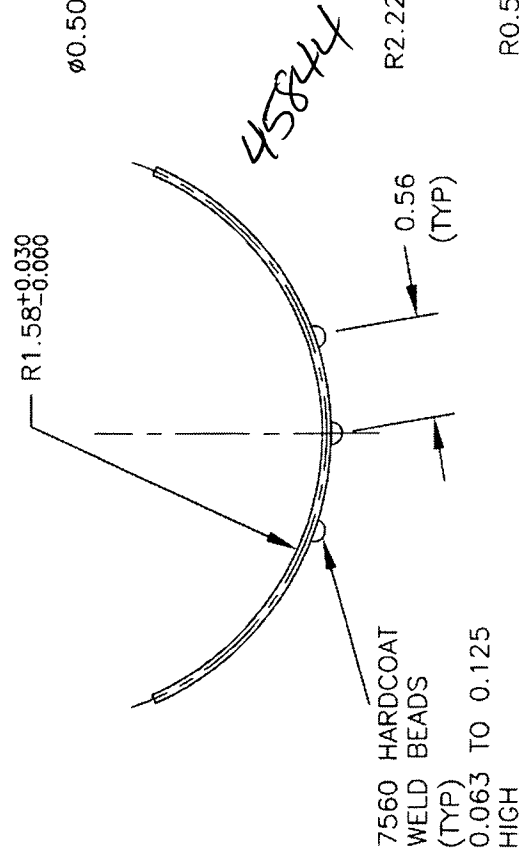
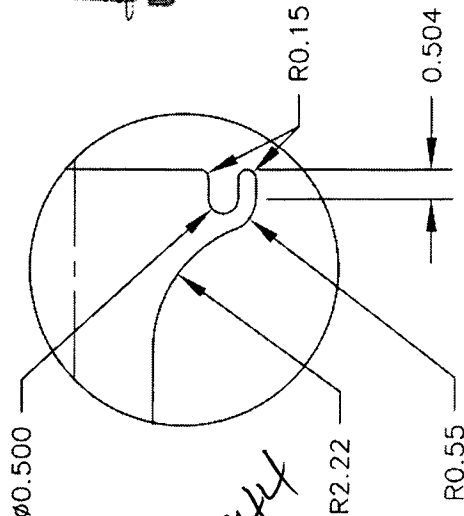
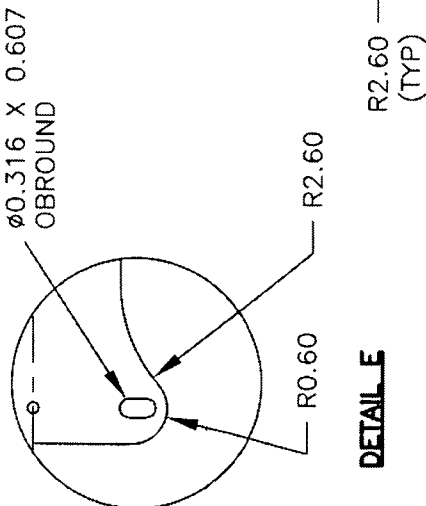
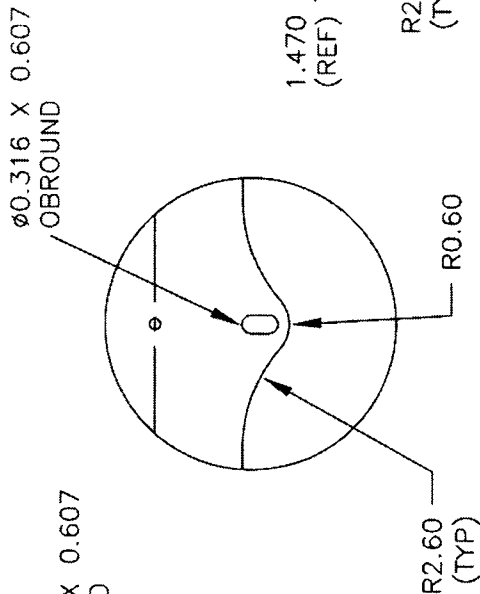
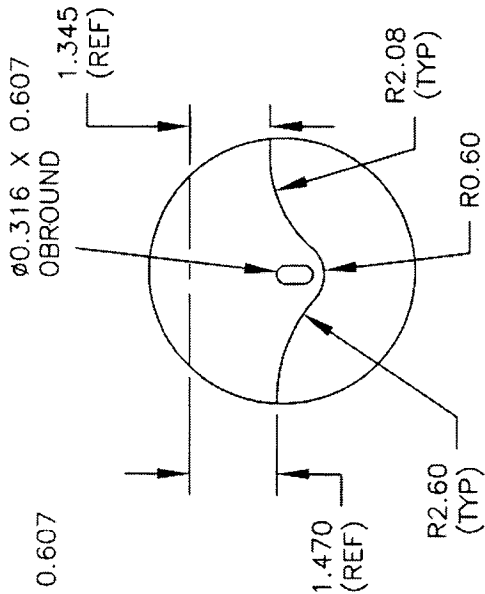
# D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3

RELEASED  
05-09-30



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